

SMALL FAB

6910



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBEM632V3008102
Job Sheet 180308



4905

DAS
13
9-89

Part No: RBEM632V3008102 Job Qty: 1 ea

Part Name: Output Flange Seal Exchange



Part Weight: 0 lbs

Status: At Planning

Priority: High

Job Created: 7/4/18

Job Tracking No:

Due Date: 7/23/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBEM632V3008102 Rev. C IPP Rev. A 18.06.05 new issue DP Verify DD

Ship Via:

SHIP
ZIT
7-28
26

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/23/18	7/23/18	0.00	0.00	Start Up Small Fab-4		MCC
110	Small Fab	1 pcs	7/23/18	7/23/18	0.00	1.00	Small Fab-4		MCC DAS 38
120	QC	1 pcs	7/23/18	7/23/18	0.00	0.00	QC5		9-89
130	Packaging	1 pcs	7/23/18	7/23/18	0.00	0.00	Packaging3-1		JRB
140	QC21-FG	1 Ea	7/23/18	7/23/18	0.00	0.00	QC21		21 AUG 09 2018

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1450-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
RBEM632V3008102-4 to RBEM632V3008102-2 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1450-E	Case	1 Ea (1 ea)	90-Start up Operation	5006348
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	110-Small Fab	5089128
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	110-Small Fab	5021040
RBEM632V3008102-10	Press	1 Ea (1 ea)	110-Small Fab	5045100068
RBEM632V3008102-2	Top Foam 1.79 X 10.47 X 14.89 (Ethafom 220. Black)	1 pcs (1 ea)	110-Small Fab	50 FM138587-24
RBEM632V3008102-3	Bottom Foam 4.26 X 10.47 X 14.89 (Ethafom 220. Black)	1 pcs (1 ea)	110-Small Fab	FM138587-23
RBEM632V3008102-4	Location Placard	1 Ea (1 ea)	110-Small Fab	5090280
RBEM632V3008102-5	Body	1 Ea (1 ea)	110-Small Fab	5099604
RBEM632V3008102-6	Support Ring Assembly	1 Ea (1 ea)	110-Small Fab	5099989

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	APP-1450-E	1	1	0
110-Small Fab	97524A032	4	247	0
	RB41011	1	842	0
	RBEM632V3008102-10	1	0	0
	RBEM632V3008102-2	1	1	0
	RBEM632V3008102-3	1	1	0
	RBEM632V3008102-4	1	1	0
	RBEM632V3008102-5	1	0	0
	RBEM632V3008102-6	1	0	0

Part Specifications

Specifications could not be found.



Container No: S100112



Part: RBEM632V3008102

Job No: 180308

Serial No/Batch: S100112

Revision: C

Inspector:

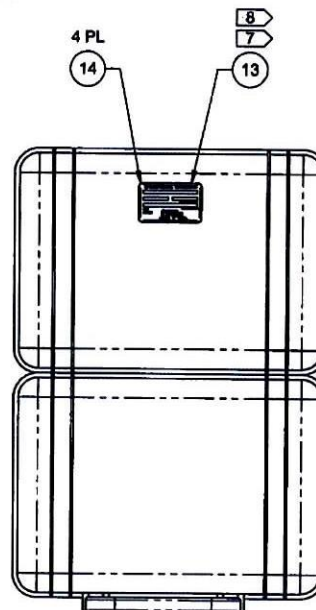
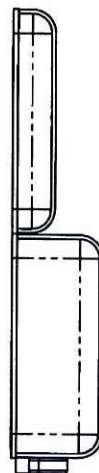
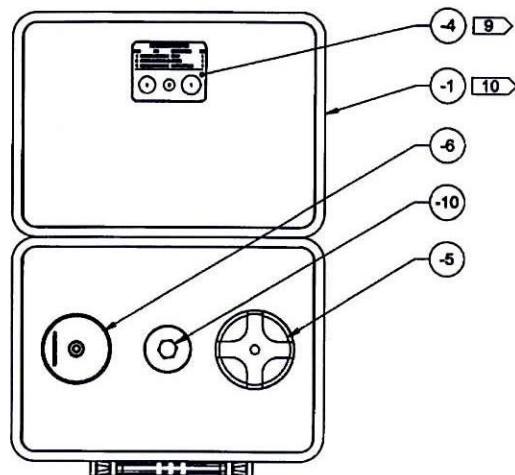
Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/08/18

ITEM #	QTY	PART #	PART TITLE
-1	1	RBEM632V3008102-1	PACKAGING ASSY
-4	1	RBEM632V3008102-4	POSITION PLACARD
-5	1	RBEM632V3008102-5	BODY
-6	1	RBEM632V3008102-6	SUPPORT RING ASSY
-10	1	RBEM632V3008102-10	PRESS
13	1	RB41011	DART PLACARD
14	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. x 0.425" LG.



RBEM632V3008102 OUTPUT FLANGE SEAL EXCHANGE

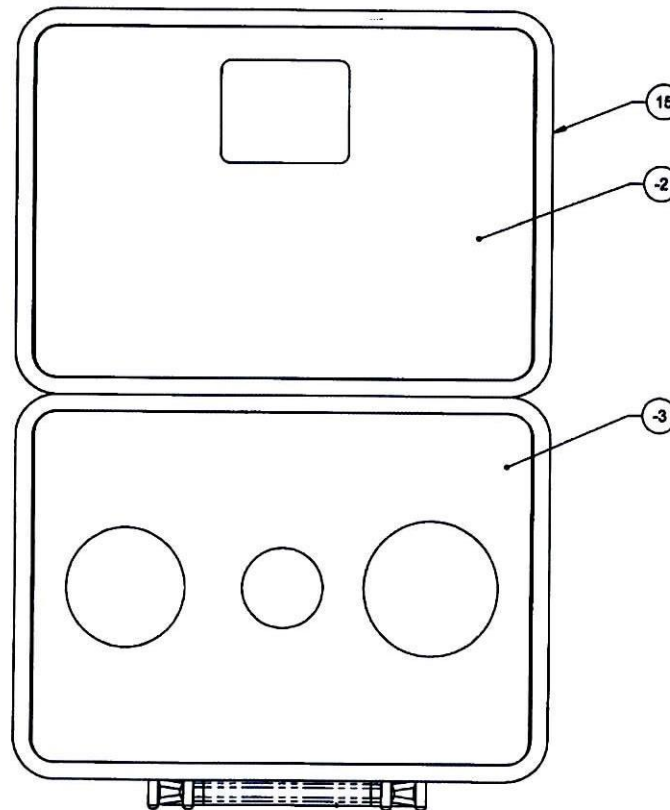
NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: ENGRAVE THE TOOL P/N & S/N ON THE DART PLACARD WHERE INDICATED
- 8) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINIUM POP RIVETS
- 9) HOT GLUE THE PLASTIC PLACARD ONTO THE TOP FOAM
- 10) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE

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WORK ORDER
NO. 18033
20180710

TEMPLATE UPDATED, PART NUMBERS CHANGED PER DART'S STANDARD, NOTES ADDED, RIVETS ADDED TO SHEET 1, -1 DRAWING ADDED, -4 MULTICRAFT PLASTICS #LM922402 MATERIAL ADDED, -5 DIMENSION 3.544 +/- 0.001" CHANGED FOR 3.550/3.555, DIMENSIONED PER DART'S STANDARDS, FINISH ZINC PLATE AND POWDER COAT REMOVED, MATERIAL 4140/4142 CHANGED FOR SS 303/304/316, -6 HARDWARE IN STEEL CHANGED FOR SS, -8 DIMENSION 3.540 +/- 0.001" CHANGED FOR 3.548/3.540, ENGRAVING ADDED, NOTES ADDED, DIMENSION M64 x 1.5 - 6H CHANGED FOR M64 x 1.5 - 6H LEFT HAND, MATERIAL 4140/4142 CHANGED FOR SS 303/304/316-9 McMaster#1078N13 CHANGED FOR McMaster#98863A368, CENTER DRILL NOTE ADDED		VM
REV.	DESCRIPTION	ECN #
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RBEM632V3008102 TITLE OUTPUT FLANGE SEAL EXCHANGE SCALE NTS DATE 6/6/2018 COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.
DRAWN	KPT	
CHECKED	DP	
MFG. APPR.	DP	
APPROVED	DP	
REV. C SHEET 1 OF 13		

ITEM #	QTY	PART #	PART TITLE
-2	1	RBEM632V3008102-2	TOP FOAM
-3	1	RBEM632V3008102-3	BOTTOM FOAM
15	1	PELICAN #APP-1450-E	PELICAN CASE 1450



RBEM632V3008102-1 PACKAGING ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A

- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A

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DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	<i>[Signature]</i>	TOOL PART #	REV. C
MFG. APPR.	DP	RBEM632V3008102	SHEET 2 OF 13
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE 6/6/2018		OUTPUT FLANGE SEAL EXCHANGE	NTS
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